

*BAAH - NOW*

Date: Tuesday, 19/02/2008 11:23:37 AM  
User: Linda Lacelle

Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	SHIM
<b>Job Number</b> :	37486		
<b>Estimate Number</b> :	13188		
<b>P.O. Number</b> :		<b>Part Number</b> :	D37511
<b>This Issue</b> :	19/02/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3751 U/R
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	37473	<b>Drawing Revision</b> :	U/R
	<b>Type</b> :	<b>Material</b> :	
	SMALL /MED FAB	<b>Due Date</b> :	19/02/2008
<b>Written By</b> :		<b>Qty:</b>	12
<b>Checked &amp; Approved By</b> :		<b>Um:</b>	Each
<b>Comment</b> :	Est Rev A 08-01-30 new issue DD verified by:		



Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6S063	6061-T6 .063 Sheet
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**Comment:** Qty.: 0.0311 sf(s)/Unit Total : 0.3730 sf(s)  
6061t6 sheet .063" thick  
(M6061t6s063)  
Batch: *105225* *18-8-2-19*

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
1-Cut as per Dwg D3751  
Dwg Rev: *4R*  
Prog Rev: *4R*

*18-8-2-19*

*(16)*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

*18-8-2-19*

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

*18-02-19* *(16)* *rechecked*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

*18-02-19* *(16)*

1- Deburr if necessary

# Process Sheet

**Drawing Name:** SHIM

**Part Number: D37511**

[illegible]

**Description :**

INSPECT WORK TO CURRENT STEP

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## POWDER COATING

[illegible]

INSPECT POWDER COAT/CHEMICAL CONVERSION

[illegible]

## ~~PACKAGING RESOURCE #1~~

[illegible]

FINAL INSPECTION/W/O RELEASE

[REDACTED]

\_\_\_\_\_

11

AUTHOR

DATE \_\_\_\_\_

**Dart Aerospace Ltd**

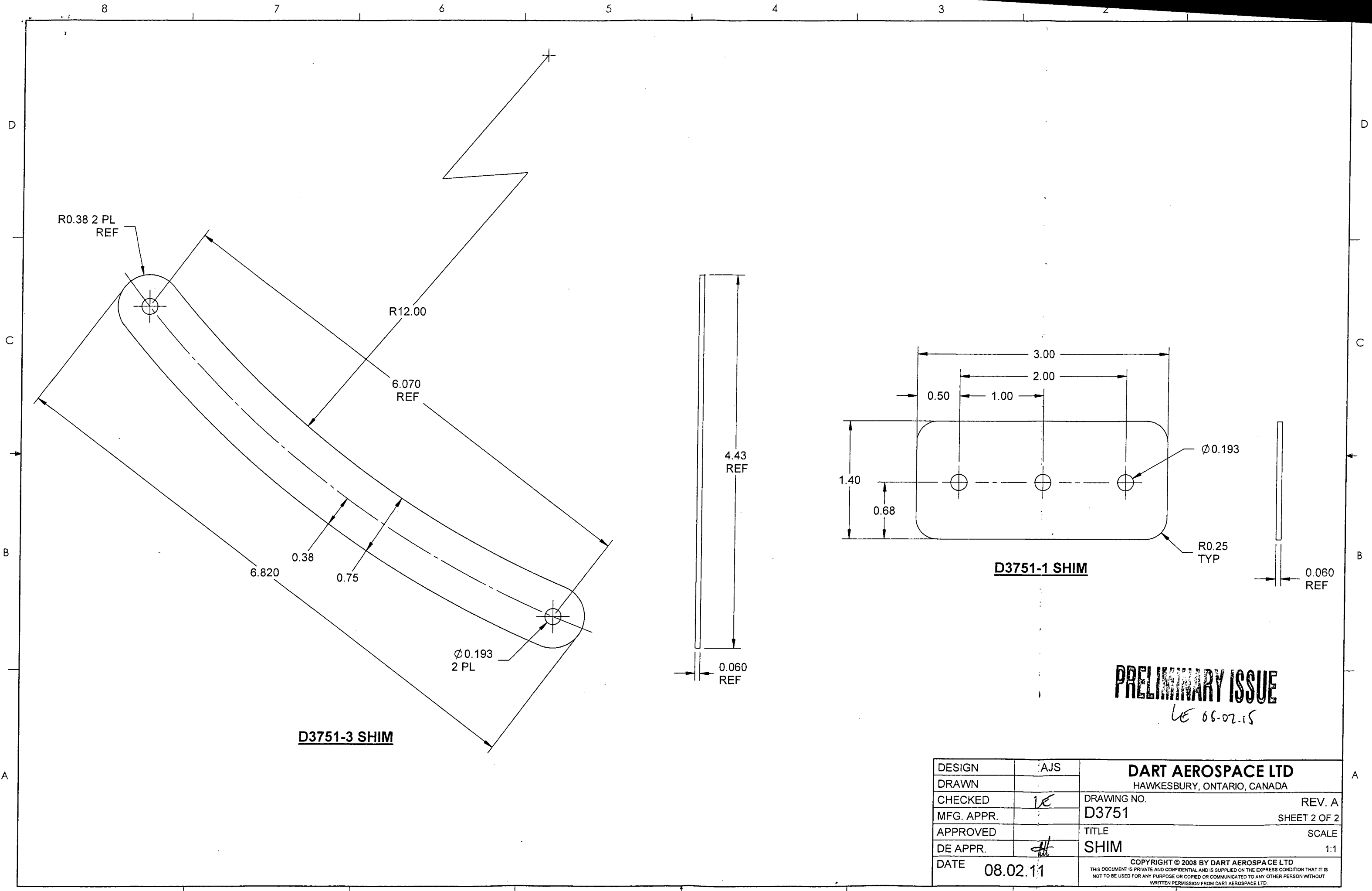
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/02/19	9	took 2 for HAI 00200	u	08/02/19	2	u	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

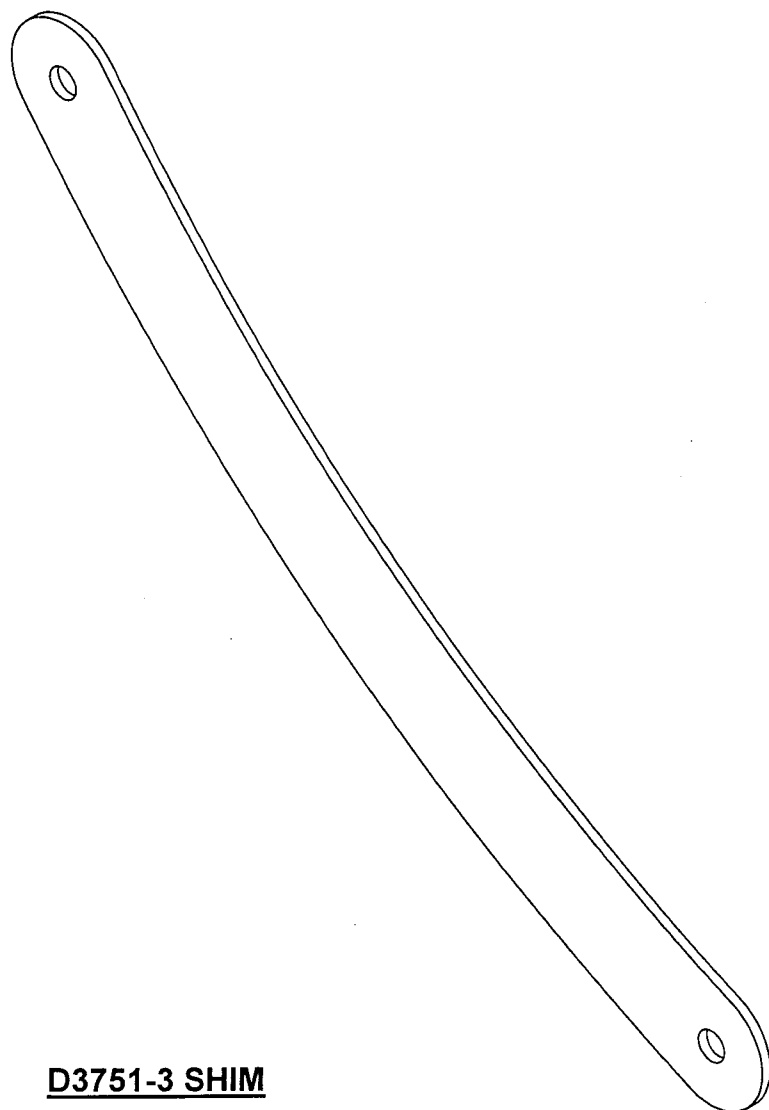
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

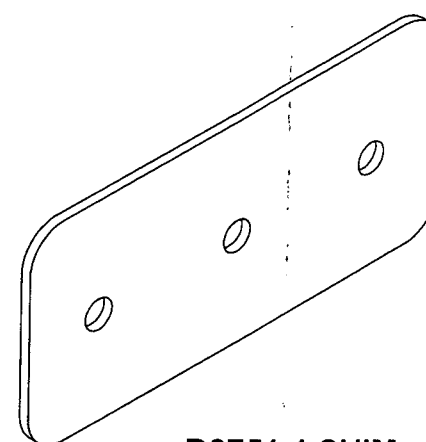
**NOTE:** Date & initial all entries



DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	<i>KE</i>	DRAWING NO.	REV. A
MFG. APPR.		<b>D3751</b>	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.	<i>KE</i>	<b>SHIM</b>	1:1
DATE	<b>08.02.11</b>	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



**D3751-3 SHIM**



**D3751-1 SHIM**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.060 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF DART SPEC M6061T6S.060)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY D3751-1 WITH DART P/N D3751-1 USING FINE POINT PERMANENT INK MARKER  
IDENTIFY D3751-3 WITH DART P/N D3751-3 USING FINE POINT PERMANENT INK MARKER  
(DO NOT IDENTIFY D3751-3)
- 7) WEIGHT: 0.02 lbs FOR D3751-1  
0.03 lbs FOR D3751-3

**PRELIMINARY ISSUE**

LE 08.02.11

A	NEW ISSUE	AJS	08.02.11
REV.	DESCRIPTION		BY DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	LE	DRAWING NO.	REV. A
MFG. APPR.		D3751	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.	HA	SHIM	NTS
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